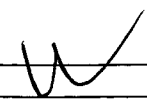
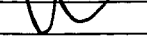


Date: Monday, 06/10/2008 10:09:46 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 42438		
Estimate Number	: 13456		
P.O. Number	:	Part Number	: D3407045
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: D3407
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 40404	Material	:
Written By	: 	Due Date	: 13/10/2008 Qty: 10 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A New Issue 08-07-09 JLM Verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34075	Ring
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3407-5	Ring	342246

Pl 08-10-28

2.0	D34077	TOW RING
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
TOW RING *342439*

Pl 08-10-28

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
Weld D3407--5 and D3803-1 using welding rod TIG174 as per Dwg D3803 & QSI 004
A/R TIG174 ROD Batch: *M101972*

Pl 08-10-27

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

10/10/29 (10)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

508/10/29 (4u)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:09:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 42438

Part Number: D3407045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109152



10X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
4:00
3:45

MF 08/10/30

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FJ 08/10/31

8.0

PACKAGING 1

PACKAGING RESOURCE #1



6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 464

8/10/31

SC

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

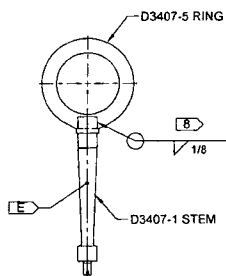
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

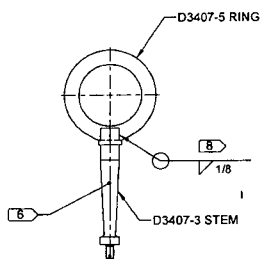
NOTE: Date & initial all entries

1042438

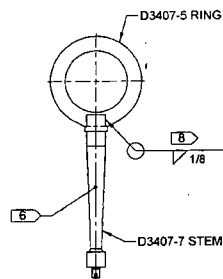
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

NOTES:

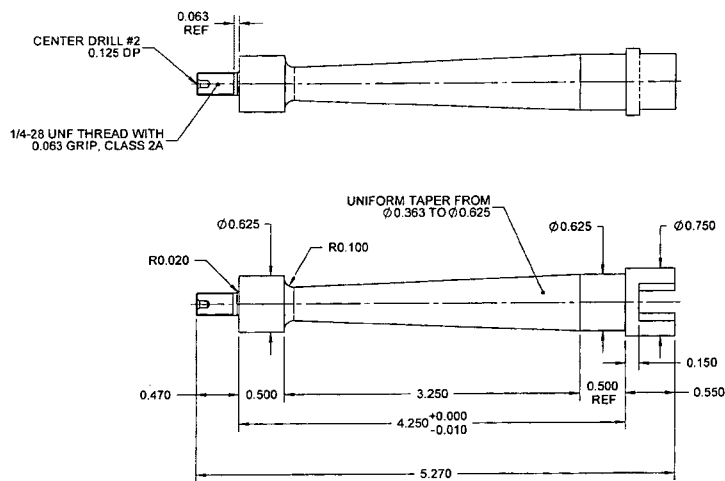
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

DESIGN	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
DRAWN	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C3-2, C3-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
CHECKED	-1/3 LONGER FOR FIT W/ WASHER	CP	05.09.09
MFG. APPR.	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
APPROVED	NEW ISSUE	CP	05.03.16
DE APPR.		BY	DATE
DATE	08.07.23		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3407** REV. **E**
TITLE **TOW RING** SCALE **NTS**

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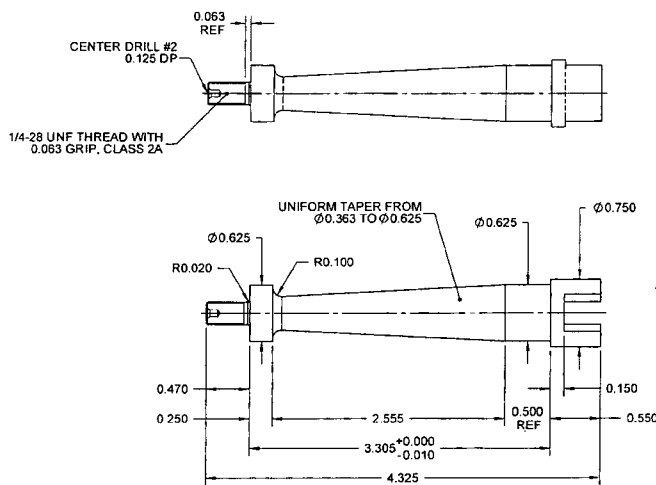
D3407-1 STEM

- NOTES:**
 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES. MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THE DOCUMENT IS PRINTED AND CHECKED ONLY AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONSIDERED AS A SUBSTITUTE FOR THE ORIGINAL DRAWING. ANY REVISIONS MUST BE MADE TO THE ORIGINAL DRAWING.</small>	

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Mo 42438



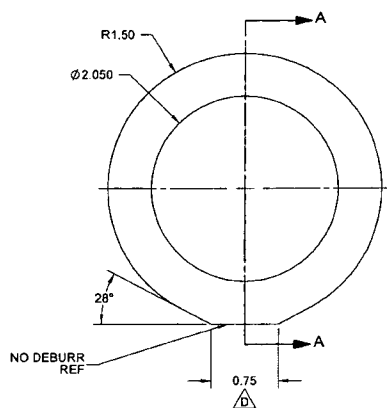
D3407-3 STEM

Wb 42438

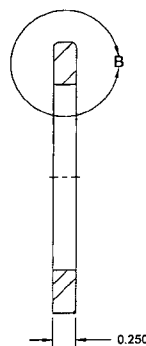
RELEASED

- NOTES
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

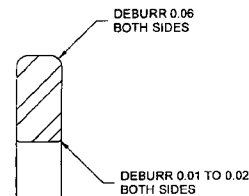
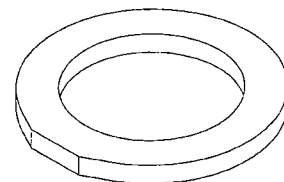
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

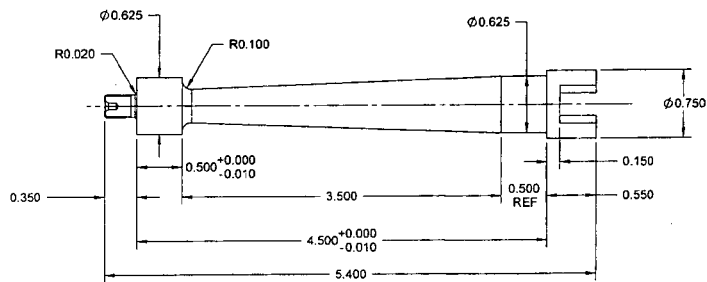
- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	1/8	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	

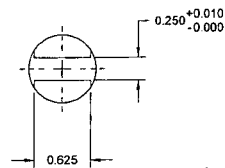
RELEASED

0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.053 GRIP, CLASS 2A








D3407-7 STEM



4042438

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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